

**Work Order ID 85733****\*85733\***

Page 1

Thursday, June 14, 2012 1:59:12 PM

Item ID: D3488-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Blade Fitting Assembly, LH

Start Date: 6/14/2012 Start Qty: 9.00

**\*9\***

Cust Item ID:

Required Date: 6/18/2012 Req'd Qty: 9.00

**\*9\***

Customer:

Reference: REWORK

Approvals: Process Plan: *MF*Date: *12-06-14*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3488

Rev B

220

Manufacture as per dwg

0.00

**\*220\***

Mill Conv

Memo

0.00

Conventional Milling Machine

PULL FROM STOCK D3488-041 X 8 B 82271

REWORK:

OPEN HOLES TO MAX TOLERANCE PER DWG

DEBURR

230

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*230\***

QC

Memo

0.00

Quality Control

*QC**8-2/2019**8*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85733****\*85733\***

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Thursday, June 14, 2012 1:59:12 PM

Item ID: D3488-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Blade Fitting Assembly, LH

Stop **\*NS2\***

Start Date: 6/14/2012 Start Qty: 9.00

**\*9\***

Cust Item ID:

Required Date: 6/18/2012 Req'd Qty: 9.00

**\*9\***

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

QC21- Final Inspection - Work Order Release

0.00

**\*270\***

QC

Memo

0.00

Quality Control

12/6/21 JG

MF 12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 14, 2012 1:59:12 PM

Page 1

Work Order ID: 85733

Parent Item: D3488-041

Parent Item Name: Blade Fitting Assembly, LH

Start Date: 6/14/2012

Required Date: 6/18/2012

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP Rev:A New Issue 06-02-28 JLM  
IPP Rev:B As per Rev B 06-03-30 JLM  
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3488-041 Blade Fitting Assembly, LH		Manufactured	No				Each	0.0000		8/			

882271

12-0618

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

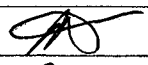
**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 85733
Description: Blade fitting		Part Number: 3488-041
Inspection Dwg: 3488 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

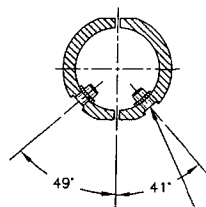
	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1)	.508	+ .008 - .001	.5155	-		RA26	✓em
	.484	+ .008 - .001	.490	-		"	"
2)	.508	+ .008 - .001	.516	-		RA26	✓em
	.484	+ .008 - .001	.490	-		"	
3)	.508	+ .008 - .001	.5145	-		RA26	✓em
	.484	+ .008 - .001	.490	-		RA26	✓em
4)	.508	+ .008 - .001	.5155	-		RA26	✓em
	.484	+ .008 - .001	.490	-		RA26	"
5)	.508	+ .008 - .001	.515	-		RA26	✓em
	.484	+ .008 - .001	.490	-		"	✓em
6)	.508	+ .008 - .001	.515	-		RA26	✓em
	.484	+ .008 - .001	.490	-		RA26	✓em
7)	.508	+ .008 - .001	.515	-		RA26	✓em
	.484	+ .008 - .001	.4905	-		RA26	✓em
8)	.508	+ .008 - .001	.515	-		RA26	✓em
	.484	+ .008 - .001	.490	-		RA26	✓em
9)							

Measured by: 	Audited by: S	Preliminary Approval:
Date: 12-06-18	Date: 17/06/15	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

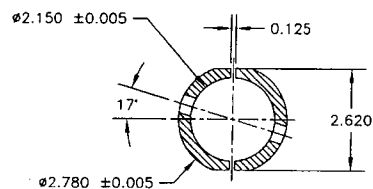




SECTION B-B

Ø0.297  
C'BORE Ø0.430 x 0.100  
INSTALL ALS4-1032-225 (OR AKS4-1032-225  
OR ALS7-1032-225 OR AKS7-1032-225)  
INSERTS AFTER FINISH  
(4 PLACES)

4



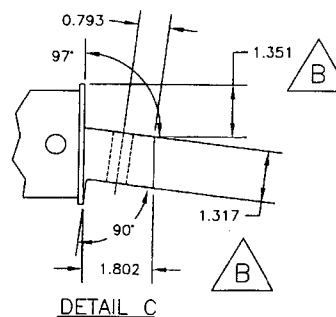
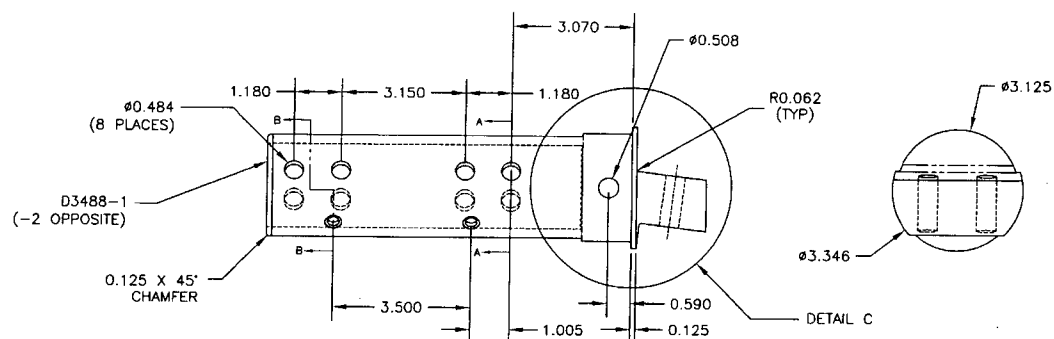
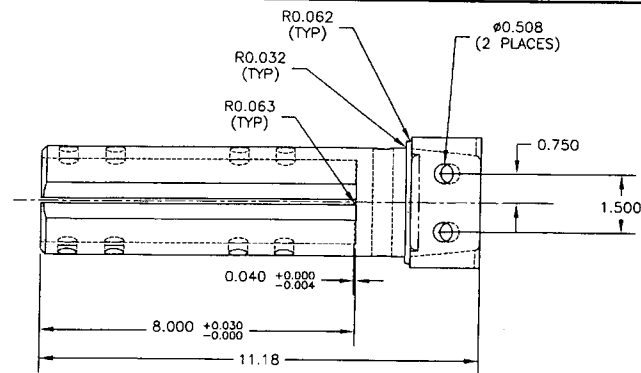
SECTION A-A

**D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

**D3488-041/-042 BLADE FITTING**

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR  
PER QQ-A-225/9  
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

**RELEASED**  
06.03.15 PH  
PER DS  
EIN #734

#8733

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
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		REV. B SHEET 1 OF 1 SCALE 1:3